



WHEN ORDERING REPLACEMENTS, STATE SERIAL NUMBER AND SIZE STAMPED ON NAME PLATE OF MACHINE, AND DESIGNATE PART BY BOTH NAME AND NUMBER.

1301	RAM	1321	RAM EXTENSION COVER PLATE
1302	PITMAN	1322	RAM EXTENSION SIDE LINERS
1303	PITMAN CAP	1323	RAM EXTENSION REAR LINERS
1304	PITMAN BOLTS	1324	FRAME REAR LINERS
1305	PITMAN AND ECC. SHAFT BUSHING	1325	FRAME SIDE LINERS
1306	PITMAN WRIST PIN	1326	FRAME SIDE LINER INSERTS
1307	PITMAN WRIST PIN BUSHINGS	1327	FRONT GIBS - RIGHT AND LEFT HAND
1308	RAM THRUST BUSHING	1328	FRONT GIB LINERS
1309	PITMAN KICKER LUG INSERT	1329	RIGHT SIDE LINER SCREWS
1310	UPPER KNOCKOUT LEVER	1330	LEFT SIDE LINER SCREWS
1312	UPPER KNOCKOUT SPRING	1333	RAM REAR LINERS
1313	UPPER KNOCKOUT LEVER FULCRUM PIN	1334	RAM SIDE LINERS
1314	UPPER KNOCKOUT DRIVE PIN	1335	RAM FRONT LINERS
1315	UPPER KNOCKOUT KICKER PIN	1349	KICKER PIN GUIDE
		1350	UPPER KNOCKOUT SPRING ADJUSTER
		1351	LEVER BUSHING

ADJUSTMENT FOR SIDE WEAR

1. REMOVE GIBS (1327).
2. LOOSEN SCREWS (1329 & 1330) IN SIDE OF PRESS FRAME AND REMOVE LINERS (1325).
3. INSTALL SUITABLE SHIMS TO FIT BETWEEN LINER (1325) AND LINER INSERT (1326), ALLOWING APPROX. .0005" PER INCH OF RAM WIDTH FOR RUNNING CLEARANCE AND REPLACE LINERS, REVERSING THE ABOVE PROCEDURE.

ADJUSTMENT FOR FRONT TO BACK WEAR

4. REMOVE LINERS (1328) AND INSTALL SUITABLE SHIMS BETWEEN THEM AND FRONT GIBS (1327). ALSO REMOVE LINERS (1324) AND INSTALL SUITABLE SHIMS BETWEEN THEM AND FRAME. ALLOW OPERATING CLEARANCE OF APPROX. .0005" PER INCH OF RAM WIDTH.
5. TO COMPENSATE FOR FRONT TO BACK WEAR ON THE BEARING OF THE RAM EXTENSION, LINERS (1323) MAY BE REMOVED AND SUITABLE SHIMS INSTALLED BETWEEN THEM AND THE FRAME, AND IF NECESSARY, REMOVE SHIMS OF THE PROPER THICKNESS FROM UNDER THE EXTENSION COVER PLATE (1321).

UPPER KNOCKOUT ADJUSTMENT

6. UPPER KNOCKOUT HAS BEEN SET FOR MAXIMUM STROKE OF KICKER PIN (1315). TO REDUCE THIS STROKE, MACHINE OFF PITMAN KICKER LUG INSERT (1309).

CAUTION

NEVER INCREASE KICK BEYOND MAX STROKE (PER TOOL & DIE SPACE) SINCE THAT WILL CAUSE FAILURE IN UPPER KNOCKOUT MECHANISM.